June-19-12 12:02:20 PM

Item ID: TRevision ID: Item Name:	D3204-041 Release Pedal	Accambly		Accept	*N900	0040	100)*	Setup St	I N	IS1*
Start Date: Required Date: Reference:	19/06/2012	Start Qty: 4.00 Req'd Qty: 4.00	*4°		Cust Item Customer:				5.	** ^ \	IS2*
Approvals:	Process Pla	n: <u>M</u> L T	Date: 12/0	6/19Tooling:	D	ate:				art *N	IR1*
	QC:		,	•	D	ate:			St	^{top} *\	IR2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. • Stamp
Draw Nbr	Rev	ision Nbr						· · · · · · · · · · · · · · · · · · ·			
D3204	Rev	A1									
*100 *100* Large Fab Large Fab		2- Drill #4 to weld.	0 diameter hole in the weld compound to plu	0.00 0.00 204 using Jig D3204-041T1 center of Ø0.760" c'bore on D g the hole after assembly. 4- C	•			G	E	13-1-	<i>t</i> y
*110 *110*		QC9- Inspect visual per	QSI004- Fusion Weld	ds 0.00				4	i Di	B-	0607
QC Quality Control		Memo		0.00						&	

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	: <u></u>	_ QA: N/C Cid	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		on B	Verific	cation		Approval	
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC inspector
		3					-		
									Jak J
					· []

Work Order ID 85997 Page 2 June-19-12 12:02:20 PM Item ID: D3204-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Release Pedal Assembly **Start Date:** 19/06/2012 Start Qty: 4.00 **Cust Item ID: Required Date:** 03/07/2012 Req'd Qty: 4.00 **Customer:** Reference: Run **Approvals:** Process Plan: Date: Tooling: Date: Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID **Description Run Hours** Number Stamp Code Qty **Qty** 120 QC5- Inspect part completeness to step on W/O *120* 0.00 13.1.7 Memo Quality Control 130 Chemical Conversion Coat per OSI005 4.1 0.00 *130* HandFinish 0.00 Memo Hand Finishing 140 Grev Sandtex(Ref: 4.3, 5.6) per QSI005 4.3 0.00 M 122 966 4 d bl 13-1-8.

140

Powdercoat

Powder Coating

0.00

***Cover holes for bushing* START TIME:

OVEN TEMPERATURE FINISH TIME:

W/O:			W	ORK ORDER CHANG	BES					
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	egory:	NCF	R: Yes N	lo DQ /	A :	Date:	
		esolution:	Disposition	on: '	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC	1		tion B	Sign &	Verification		Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector
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Work Orde		997		*859								Page 3
Item ID: Revision ID: Item Name: Start Date:	D3204-041 Release Pedal 19/06/2012	Start Qty: 4.00	*4*	Accept	*N900	040	100	ገ*	Setup	Start. Stop	171.	S1* S2*
Required Date: Reference:	03/07/2012	Req'd Qty: 4.00	*4*		Customer:							
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ate:			Run	Start	*NI	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*NI	R2*
Sequence ID/ Work Center II 150 *150* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00 SW 0.00 3 1.8	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*160 *160* Small Fab Small Fab		Small Fab Memo Install D320	14-7 bushing as shown i	0.00 0.00 n Dwg D3204				4x	<u></u>			J3
170		QC5- Inspect part compl	eteness to step on W/O	0.00				4				
QC Quality Control		Memo		0.00 13,18								

Quality Control

W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	DCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	4	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Dispositio	n: <u>'</u>	_ QA: N/C (Closed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign Dat	& Secti	cation on C	Approval Chief Eng	Approval QC Inspector
•			Criter Eng	Criter Eng	Dat	5			
		-							
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Work Order ID 85997 June-19-12 12:02:20 PM			*85997*							Page 4	
Item ID: Revision ID: Item Name: Start Date: Required Date	D3204-041 Release Pedal 19/06/2012 2: 03/07/2012	Assembly Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*	Accept	*N900 Cust Item I Customer:		1100) *	Setup Sta	1/1	S1* S2*
Reference: Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):	Da	ate:		1	Run Sta	1/7	R1*
Sequence ID/ Work Center 180 *180* Packaging	ID	Operation Description Identify as per dwg & Sto	ock Location 2 - A	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *10 * QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00					13/	1 10	40

MK 13-01-10

	•									
W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE	В	У	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	NCR: \	es N	o DQ /	A:	_ Date: _	
		esolution:								
NCR:			WORK ORE	DER NON-CONFORM	IANCE (N	ICR)				
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	on Sign & Date		Secti		Chief Eng	QC Inspector
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		·								
										· ·
			1							

Picklist Print

June-19-12 12:02:24 PM

Work Order ID: 85997

85997

Parent Item:

D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1		Manufactured	No			100	Each	4.0000	1	4		· · · · · · · · · · · · · · · · · · ·	
D3204-1									**	E_	13-	-/-3	
8	5783×4			Location		Loc	Qty	Loc Code					
	- (0)			WA021			4		_		_		
2224 11		_			79294		4			-	_		
D3204-11		Manufactured	No			100	Each	8.0000	1	4			
*D3204-11	*								**	EL	/3-	/-3	
,	(11)7(1)	,		Location		Loc (<u>Oty</u>	Loc Code					
	86778 X4	<i>‡</i>		WA021			8				_		
					57522		8			<u> </u>	_		
D3204-13		Manufactured	No			100	Each	14.0000	2	8			
*D3204-13) *								**	A	13-1	-3_	
	859841	(3		Location		Loc (Qty	Loc Code					
	•	-		WA021			14		_		_		
	88177	x 2			70315		3				_		
03204-3		Manufactured	No		73465	100	11 Each	12.0000	_		-		
		ivianutactured	110			100	Еасп	13.0000		4		_	
D3204-3									**	\mathcal{A}	/3-	-1-3_	
				Location		Loc C	<u>Oty</u>	Loc Code					
				WA019			13		_		_		
					79801		13				_		

86709 X4

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					:				
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
		esolution:	Disposition	on: '	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	3)			
DATE	STEP	Description of NC			tion B	Verifi	cation		Approval
DAIL	O L	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		ion C	Chief Eng	QC Inspector
									1
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;									:

June-19-12 12:02:24 PM

Work Order ID: 85997

85997

Parent Item:

D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D3204-5

100

100

160

Each 4.0000

**

**

FL 13-1-3

13-1-3

86702 X4

Manufactured

Manufactured

Location WA021

Loc Qty 4 Loc Code

7.0000

D3204-9

85980x3 87104X1

D3204-7 Manufactured

Bushing

Location WA020

Location

GA

79803

77091 79802

79292

Loc Qty 7

Loc Qty

6

Each

Each

7.0000

Loc Code

**

Loc Code

June-19-12 12:02:25 PM

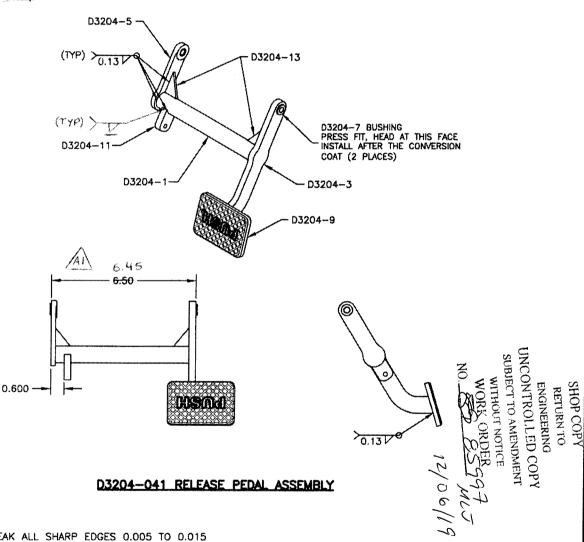
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	aory:	NCR: Yes	No DQ	 A:	Date:	
		esolution:							
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NC	₹)			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descript		on B			Approval Chief Eng	Approval QC Inspector
		Codion	Chief Eng	Chief Eng	Date	0001	011 0	5.1101 Ling	To mopostor
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	CHECK	(ED, A	APPROVED	DRAWING NO.	REV. A
,		#	1	D3204	SHEET 1 OF 3
	DATE		***************************************	TILE	SCALE
	04.0	1.27		RELEASE PEDAL ASSEMBLY	NTS
	Α		04.01.27	NEW ISSUE	
	Α١	# 1	05.07.15	6.45 WAS 6.50	





- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125) 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
 7) WELD ASSEMBLY PER QSI 004

- CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 11) ALL DIMENSIONS ARE INCHES

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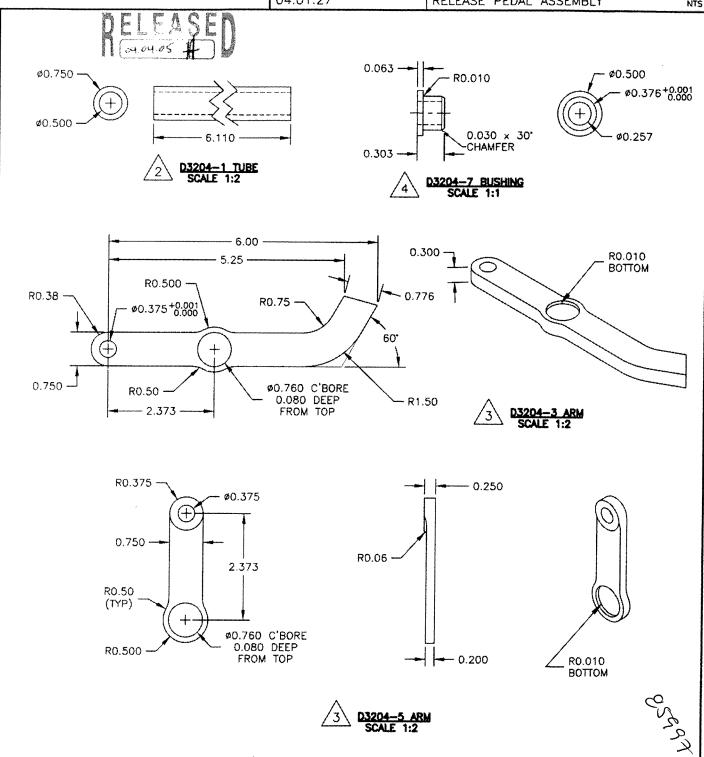
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W/O:			WC	RK ORDER CHANG	ES		· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Ye	s No	DQA:	Date: _	
	Re	esolution:	Disposition	n: <u>'</u>	_ QA: N/C	Closed	l:	Date: _	
NCR:			WORK ORDER NON-COM						
DATE	STEP	Description of NC		Corrective Action Section B			erification	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		n & ite	Section C	Chief Eng	QC Inspector
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DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED .	APPROVED	DRAWING NO.	REV. A
DATE		TITLE	SHEET 2 OF 3
04.01.27		RELEASE PEDAL ASSEMBLY	NTS



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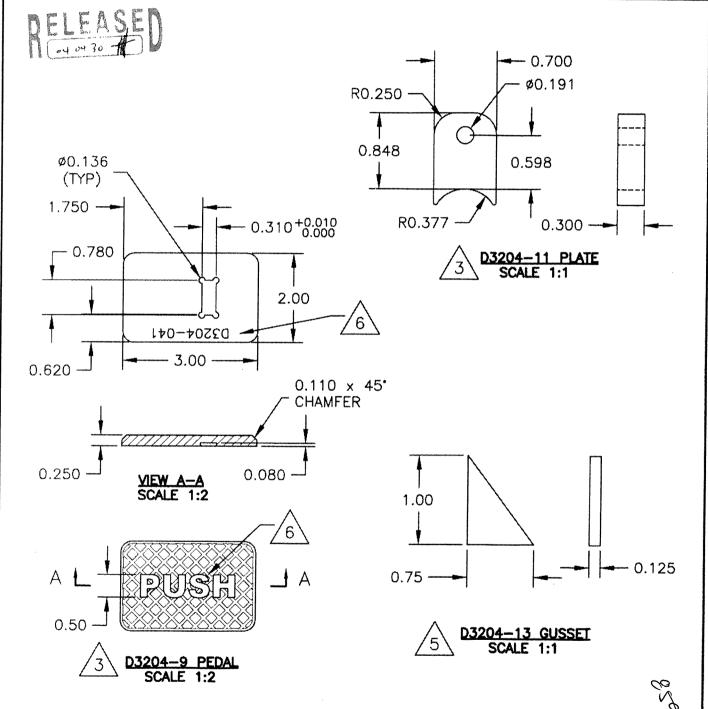
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W/O:			WO	RK ORDER CHANG	GES					
DATE STEP		PRO	PROCEDURE CHANGE			y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date		on C	Chief Eng	QC Inspector	
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CHECKED	APPROVED	DRAWING NO.	REV. A
1	-#	D3204	SHEET 3 OF 3
DATE	1144	TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS



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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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DATE	STEP	Description of NC	Corrective Action Section B			Verification	Approval	Approval			
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